

Slip 30.31/101

Dart Aerospace Ltd.

Date: Thursday, 25/10/2007 2:34:57 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 35401	
Estimate Number : 12576	
P.O. Number :	Part Number : D3562041
This Issue : 25/10/2007 S.O. No. :	Drawing Number : D3562 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 35262	Material :
Written By :	Due Date : 01/11/2007 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B34694

Check Material for any Dents or Defects

SE 01.10.25

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SE 01.10.25

SE 07.10.25

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SE 07.10.26

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SE 07.10.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 25/10/2007 2:34:57 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35401

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.10.27

6.0

D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
ARM WELDMENT

334474

07.10.27

7.0

D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
ARM WELDMENT
Batch: 334476

07.10.27

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)
Blind Rivet
batch: 05125

07.10.27

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: 104677

07.10.27

07.10.27

07.10.27

07.10.27

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.10.27

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-10-30	17A	Install bushing D2808 #B <u>32896</u>	mf	07-10-30	2			
07/10/30	17B	inspect Qc level 25	S	07/10/30	(1)			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 25/10/2007 2:34:57 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35401

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

334485

Handwritten: 07.10.29 (1)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

Handwritten: 07.10.29 1

2-Grind end cap welds flush as per Dwg D3562

Handwritten: 07.10.29 1

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 07.10.29 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 07.10.30

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: 1) TOUCH-UP END CAPS

Handwritten: M105914

Handwritten: 07-10-30 (1)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch:

M106030

Handwritten: M-4

Handwritten: 07/10/30

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: MK

Handwritten: 07-10-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 25/10/2007 2:34:57 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35401

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

07.10.31 (1)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.31

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.10.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

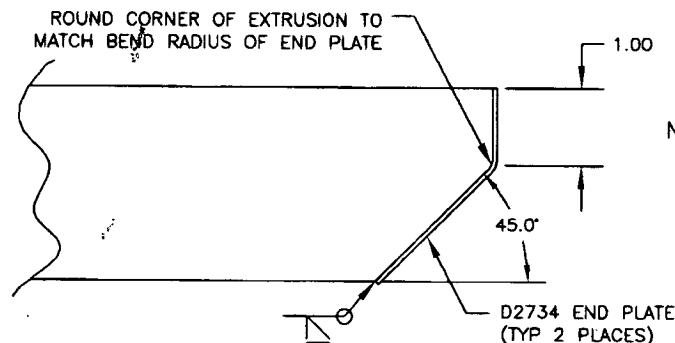
NOTE: Date & initial all entries

DART

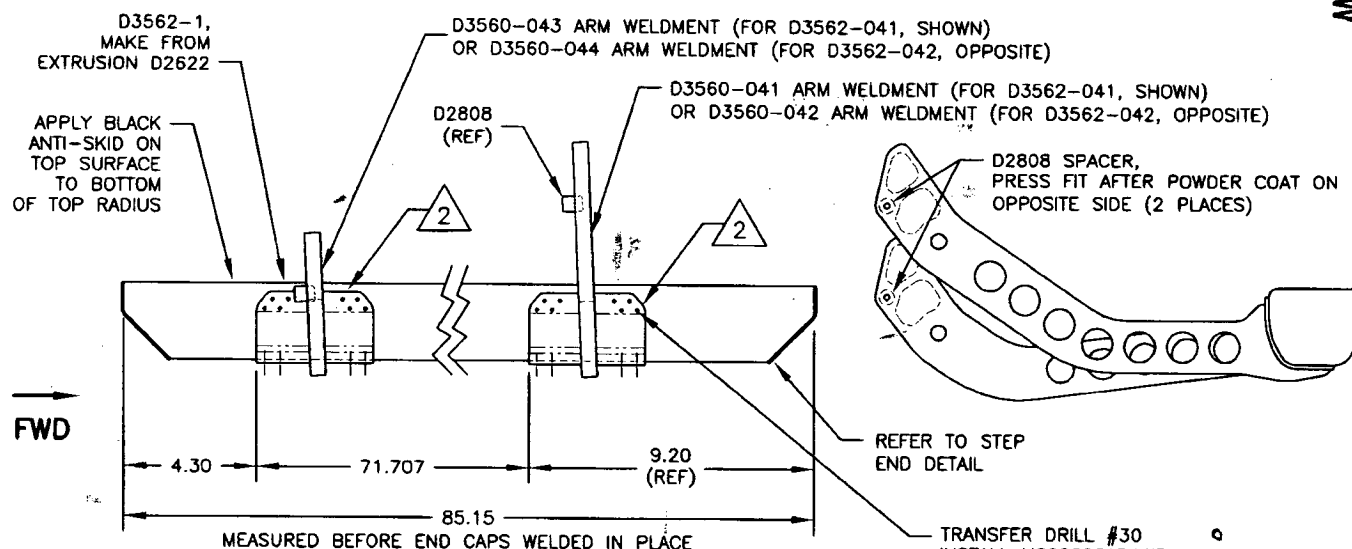
RELEASED
07.06.24
07.10.22 DC

UNDER REVIEW

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6) OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
07.06.19	06.09.26	NEW ISSUE
07.01.15	07.06.19	ARMS NOW RIVETED TO STEP
07.06.19	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVTS
CHECKED	APPROVED	DRAWING NO. D3562
DATE	TITLE	STEP ASSEMBLY
SCALE	NTS	SHEET 1 OF 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries